

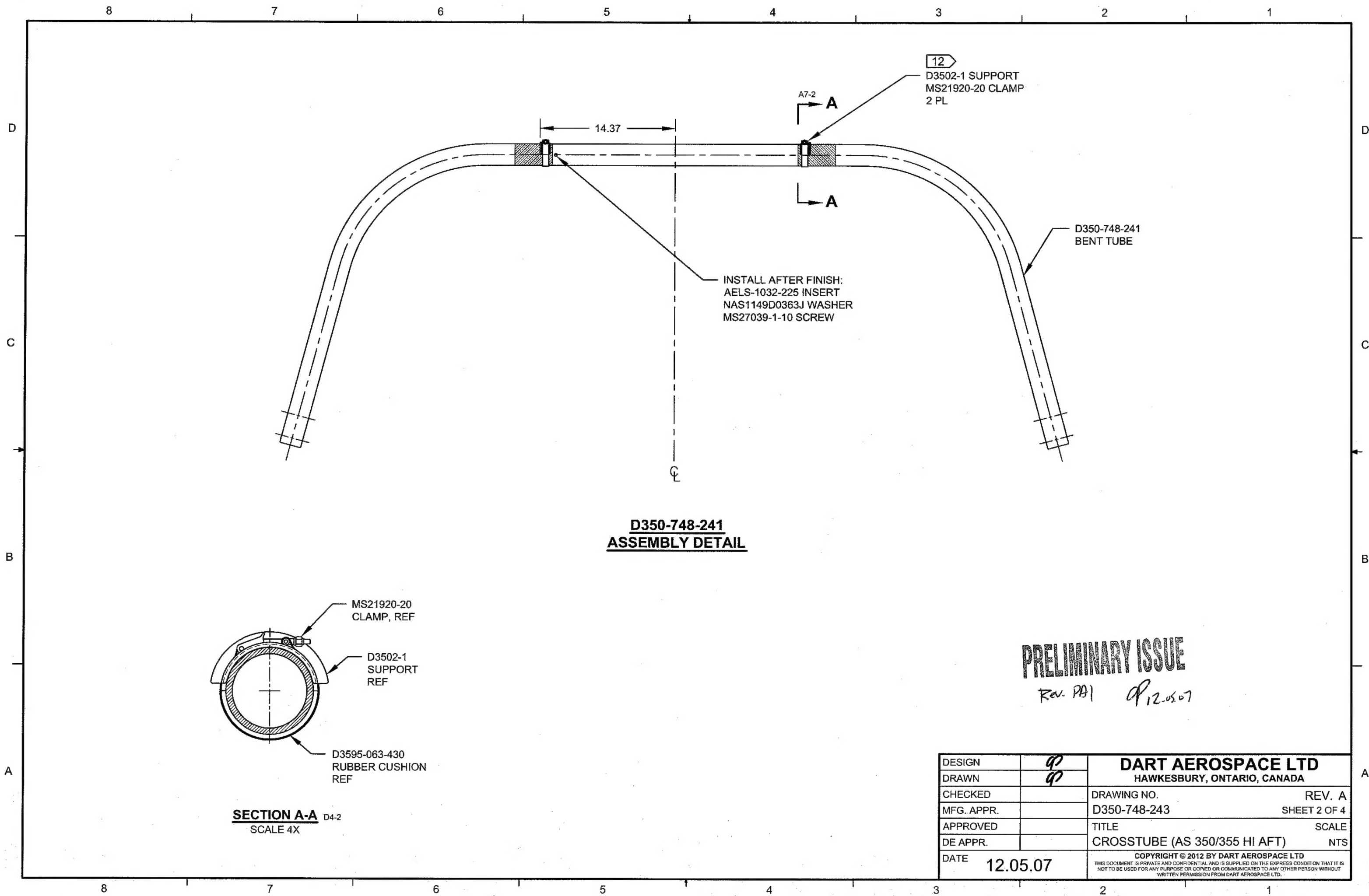
| Item | Qty<br>-243 | Part Number   | Description                            |
|------|-------------|---------------|--|
| 1    | X           | D350-748-243  | CROSSTUBE ASSEMBLY (AS 350/355 HI AFT) |
| 2    | 1           | D6021-125     | CROSSTUBE (OR D6018-125)               |
| 3    | 2           | D3502-1       | SUPPORT                                |
| 5    | 1           | AELS-1032-225 | INSERT                                 |
| 6    | 1           | NAS1149D0363J | WASHER (OR AN960JD10)                  |
| 7    | 2           | MS21920-20    | CLAMP (PER DART SPEC. M-MS21920-20)    |
| 8    | 1           | MS27039-1-10  | SCREW                                  |

**GENERAL NOTES:**

- 1) MATERIAL: MANUFACTURED FROM D6021-125 (17-4PH)  
FINISHED LENGTH = 122.700±0.06
- 2) FINISH: PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: DART PART NUMBER "D350-748-243" AND BATCH NUMBER ON INSIDE OF CUFF  
PER DART QSI 044 6.4 (VIBRATING STYLUS)
- 7) WEIGHT: 29.85 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.297 HOLE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT ALL EDGES FROM MACHINING  
LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER  
BENDING.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO  
BENDING IS 6% BASED ON O.D.
- 11) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE  
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES,  
NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY.  
CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE  
MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO  
CRACKING/CHIPPING/GROOVES.
- 12) TORQUE CLAMPS 60 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT  
NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
- 13) MAX TWIST AFTER BENDING: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN  
CUFF HEIGHTS FROM THE SURFACE MAY BE NO LARGER THAN 0.25 (ZN C1-3).

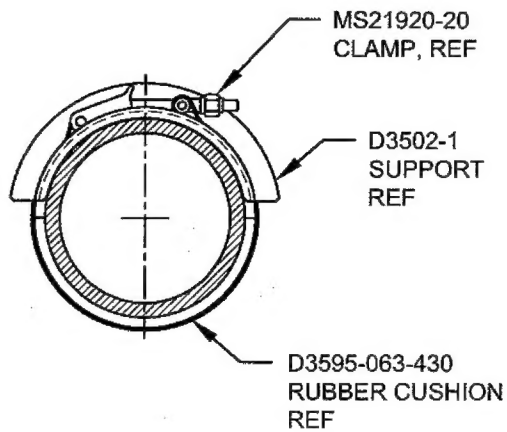
**PRELIMINARY ISSUE**  
Rev. DB1 P12.05.07

|            |             |  |  |          |
|------------|-------------|--|--|----------|
| A          | NEW ISSUE   |  | CP   | 12.05.07 |
| REV.       | DESCRIPTION |  | BY   | DATE     |
| DESIGN     | q           | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |  |          |
| DRAWN      | q           |  |  |          |
| CHECKED    |             | DRAWING NO.  | REV. A   |          |
| MFG. APPR. |             | D350-748-243   | SHEET 1 OF 4   |          |
| APPROVED   |             | TITLE  | SCALE  |          |
| DE APPR.   |             | CROSSTUBE (AS 350/355 HI AFT)                            | NTS  |          |
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**D350-748-241  
ASSEMBLY DETAIL**

**PRELIMINARY ISSUE**  
Rev. PA1 12.05.07

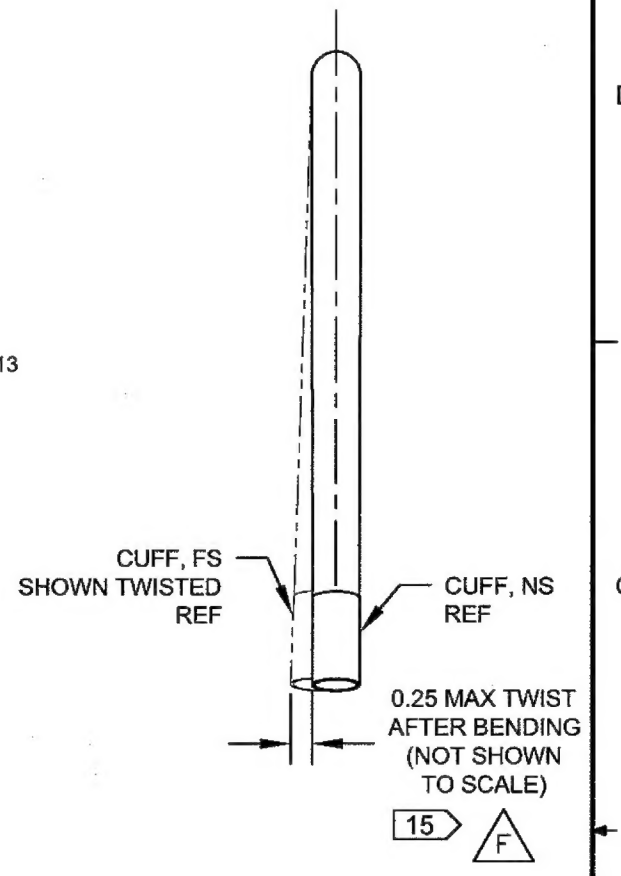
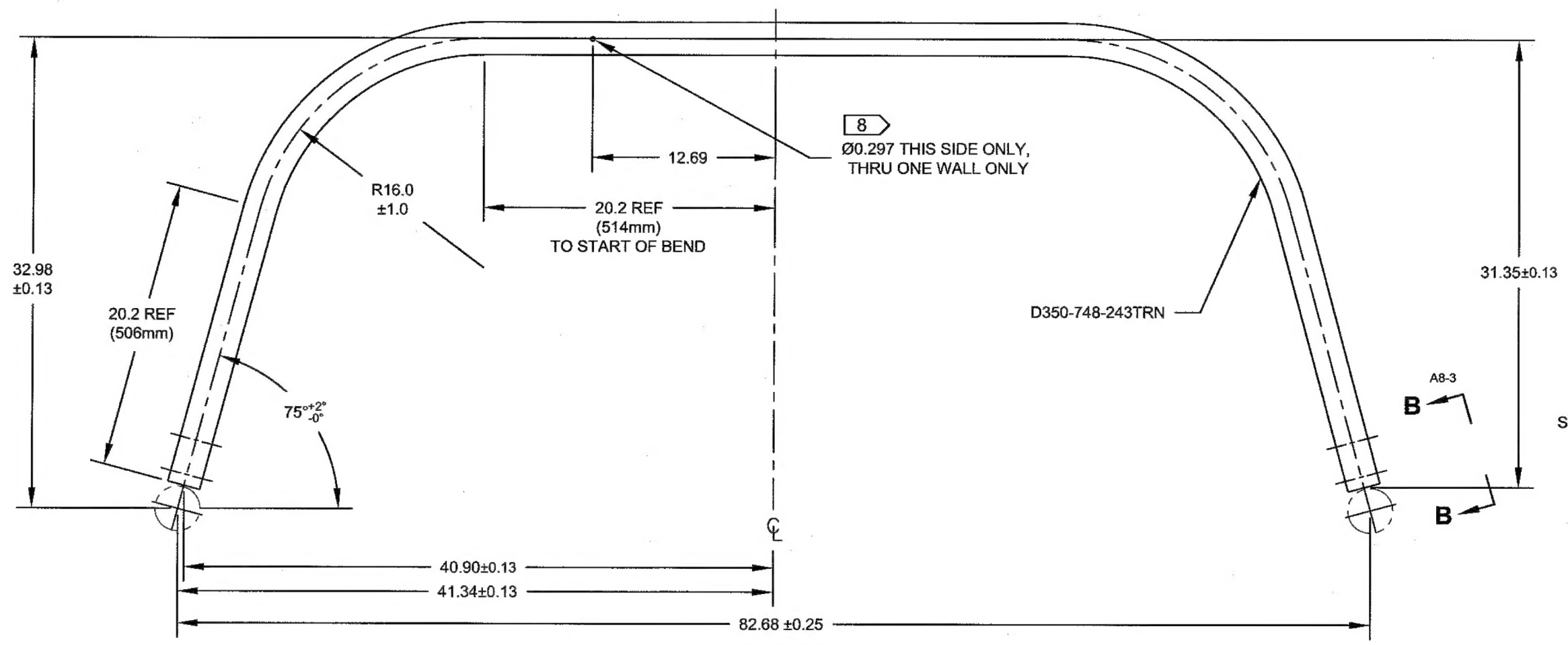


**SECTION A-A** D4-2  
SCALE 4X

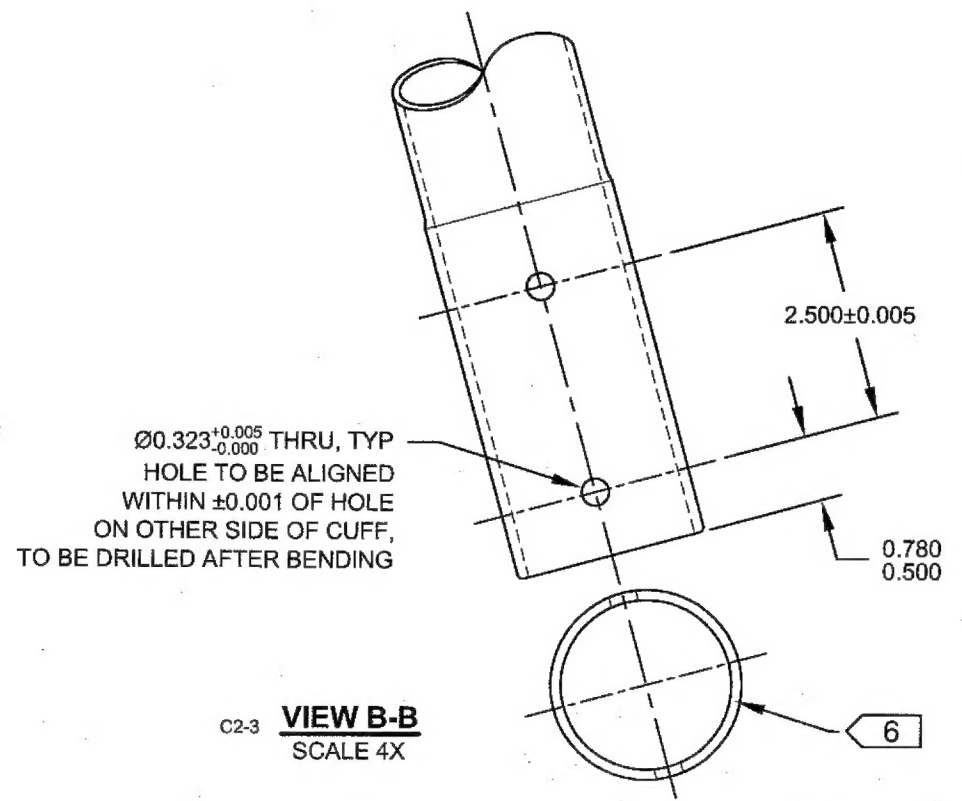
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| DRAWN      | Q        | HAWKESBURY, ONTARIO, CANADA  |              |
| CHECKED    |          | DRAWING NO.  | REV. A       |
| MFG. APPR. |          | D350-748-243   | SHEET 2 OF 4 |
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8 7 6 5 4 3 2 1

D  
C  
B  
A



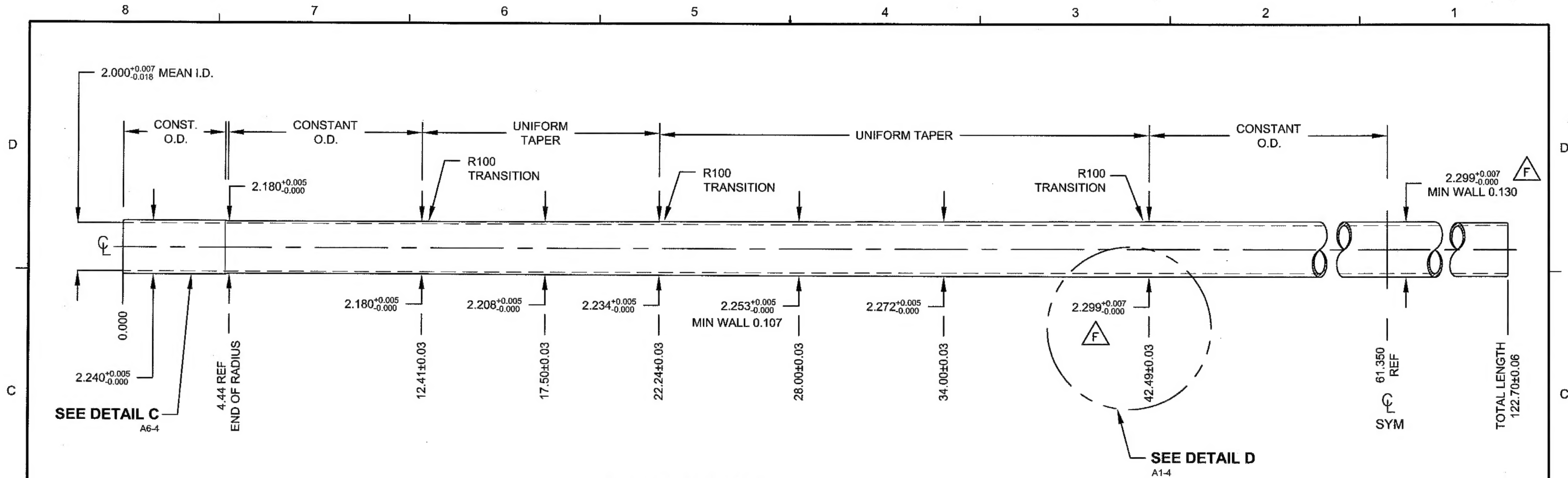
**D350-748-241**  
**BENDING AND DRILLING DETAIL** 10



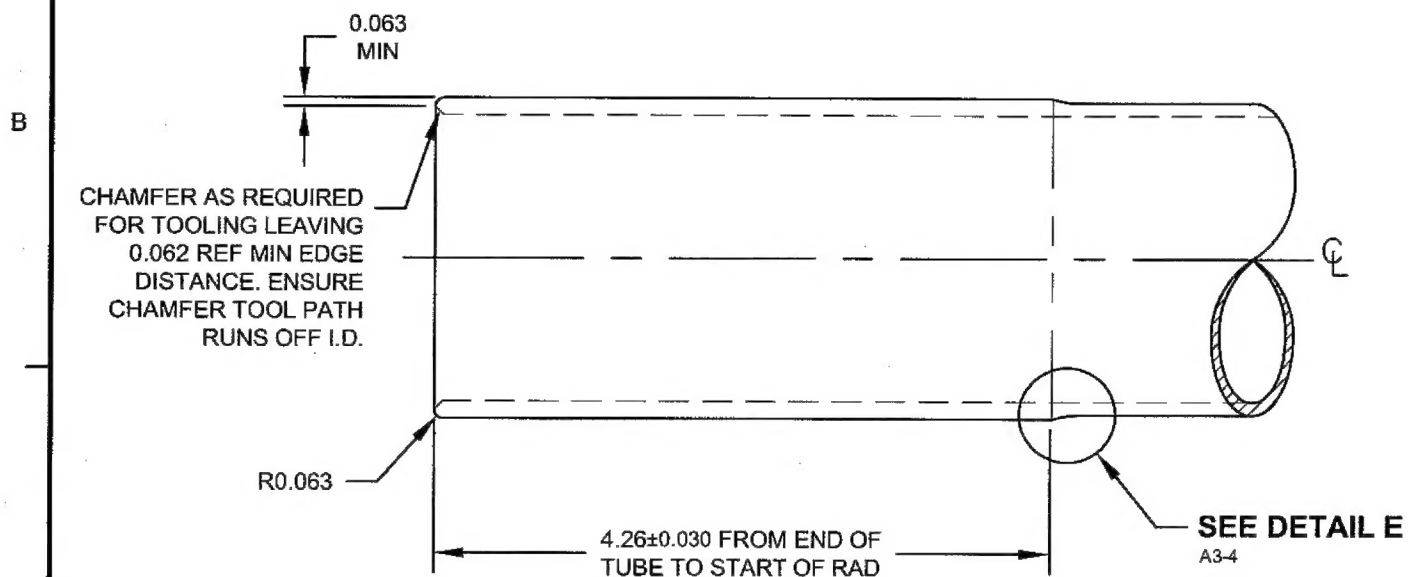
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Rev. PA1 12.05.07

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| CHECKED    |          | DRAWING NO.   | REV. A       |
| MFG. APPR. |          | D350-748-243  | SHEET 3 OF 4 |
| APPROVED   |          | TITLE   | SCALE        |
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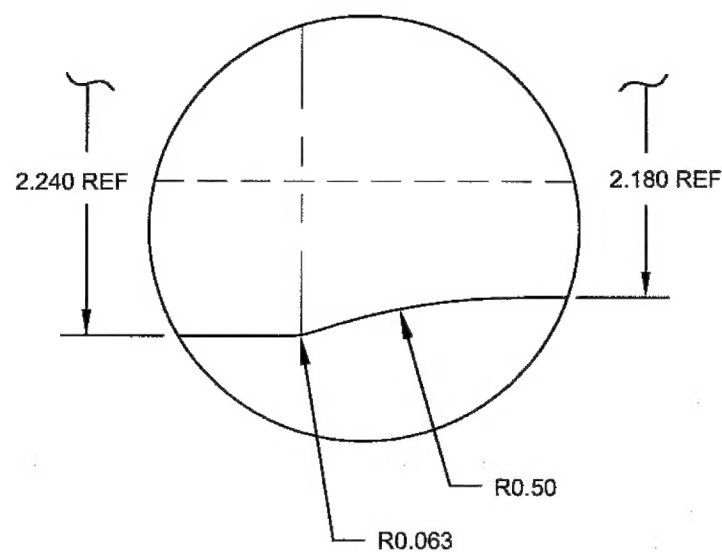
8 7 6 5 4 3 2 1



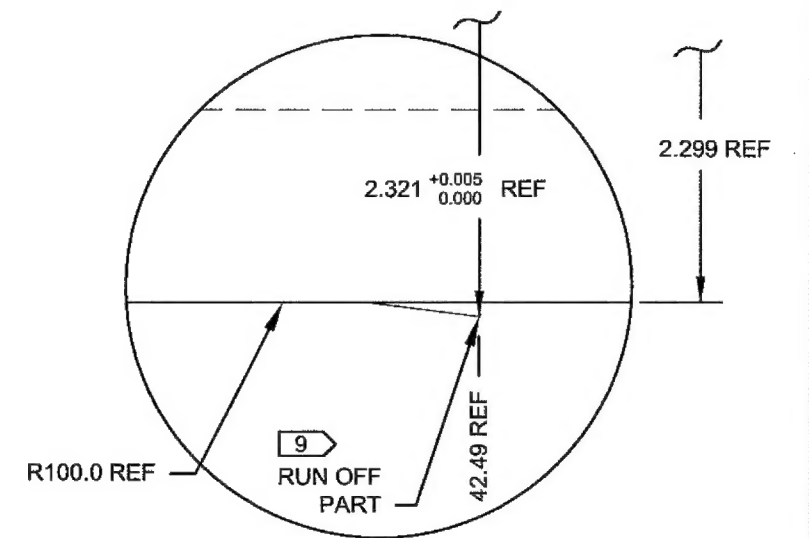
### D350-748-243TRN TURNING DETAIL



**DETAIL C:**  
**CROSTUBE CUFF** C8-4  
SCALE 3X



**DETAIL E:**  
**CUFF TRANSITION** A5-4  
NOT TO SCALE



**DETAIL D:**  
**TAPER RUN-OFF** C3-4  
NOT TO SCALE

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Rev. PA1 12.05.07

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| MFG. APPR. |          | D350-748-243   | SHEET 4 OF 4 |
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